

Date: Thursday, 1/17/2008 3:25:30 PM
 User: Kim Johnston

Process Sheet

9

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 212 BASKET BASE ASS'Y RH
 Job Number : 36820B
 Estimate Number : 11543
 P.O. Number :
 This Issue : 1/17/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3053042
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3053 REV A
 Previous Run : 29378B Project Number :
 Material :
 Due Date : 2/24/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : K Johnston 01-18
 Comment : Est. C 02.09.04 M304EX0.75-16F was M750-16FXS-S/SK
 J/R/F

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 45.5000 f(s)/Unit Total : 45.5000 f(s)
 304 SQ Tube.75x.75x.065W

Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: M107914 FC 08 04 14

2.0 D31661 Basket Hoop



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Basket Hoop

Qty. 5 D3166-1

Batch: D337611

FC 08 04 14

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
 Cut 5 D2235-3 FROM D3166-1

Drill holes in D3053-3 as per Dwg D3053

FC 08 04 14

4.0 D23273 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Spacer Bushing

Pick:

Qty Part Number

Description

Batch

2 D2327-3

Bushing

D364199

FC 08/04/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:25:30 PM

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 BASKET BASE ASS'Y RH

Job Number: 36820B

Part Number: D3053042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Pick:

Qty	Part Number	Description
2	D2232-3	Hinge plate

Batch

B36846

FC 08 04 14

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Pick:

Qty	Part Number	Description
2	D2581	Mounting Bracket

Batch

M37248

FC 08 04 14

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 50.4000 sf(s)/Unit Total : 50.4000 sf(s)

Expanded Metal Flat Stai

Pick:

Qty	Part Number	Description
48sq.ft	M304EX0.75-16F	Expanded Metal

Description

Batch

M107511

FC 08 04 14

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Remove all markings from material

Drill holes in three D2235-3 ribs as per Dwg D3053 using Jig DT8365

Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required

FC 08/04/15

P-10

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-04-16 ①

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

PD 08-04-16 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3053-042 PAR #: N/A Fault Category: Prod/Large NCR: Yes No DQA: S Date: 08/04/23
 QA: N/C Closed: S Date: 08/04/23

NCR: <u>36820B</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-04-11	8.0	Employee was Drilled D2235-3 X1 using the old drill sig DT 8365, needed to use DT 8995. Old sig not perfectly centered.	<u>JS1012</u>	Drill holes with weld as per QS1004, and grind flush. drill new holes as per drawing. Ident. by DT 8365 to not use drill holes, and block drill holes.	<u>FC</u> <u>08-04-11</u>	QC9 PD 08-04-11	<u>JS1012</u>	<u>08-04-11</u>

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:25:30 PM
User: Kim Johnston

Process Sheet

30 min.

18/0472008

S.062 09.38

#1 403.9 F

D.3053042 F

#3 F

B.36320 B F

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 BASKET BASE ASS'Y RH

Job Number: 36820B

Part Number: D3053042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Take Traveller D205-541-043 to KP

12.0

POWDER COATING

POWDER COATING

Pressure wash

FX 08/04/18

①



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

08-04-18

①

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. 08/04/18

①

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP 36820

08/04/20

①

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/23

①

Job Completion



mrf

08-04-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

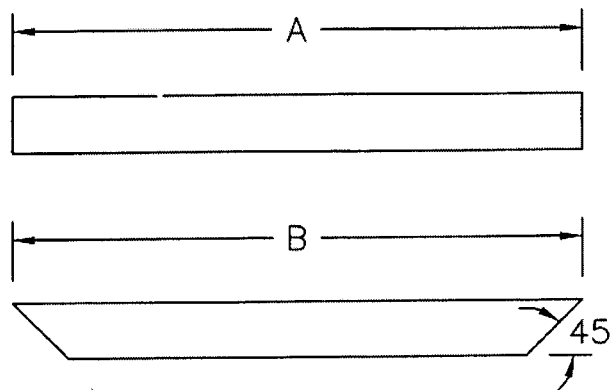


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CH	APPROVED CH	DRAWING NO. D3053	REV. A SHEET 1 OF 3
DATE 01.11.01		TITLE BASKET BASE ASSEMBLY (212)	SCALE NTS
A	01.11.01	NEW ISSUE	

RELEASED
01.12.20

PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3053-1	2	—	96.00	RIB
D3053-3	2	—	25.50	RIB
D3053-5	6	23.73	—	RIB
D3053-7	3	25.31	—	RIB
D3053-9	3	19.48	—	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-3	5	N/A	N/A	RIB



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WORK ORDER
NO. 3682013

NOTES:

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

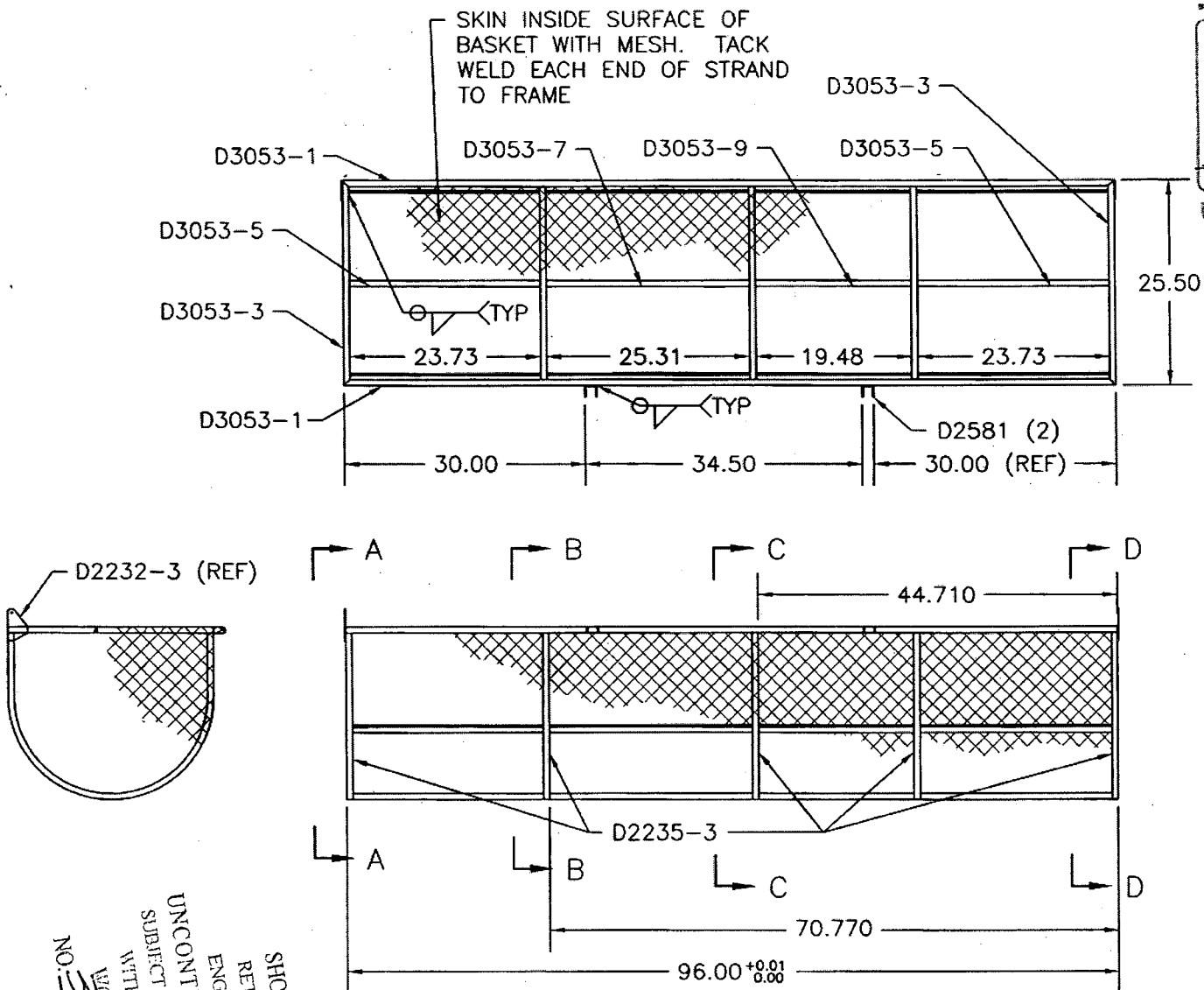
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RF	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
RF	RF	D3053
DATE	TITLE	REV. A
01.11.01	BASKET BASE ASSEMBLY (212)	SHEET 2 OF 3
		SCALE 1:20

RELEASED
01.12.20

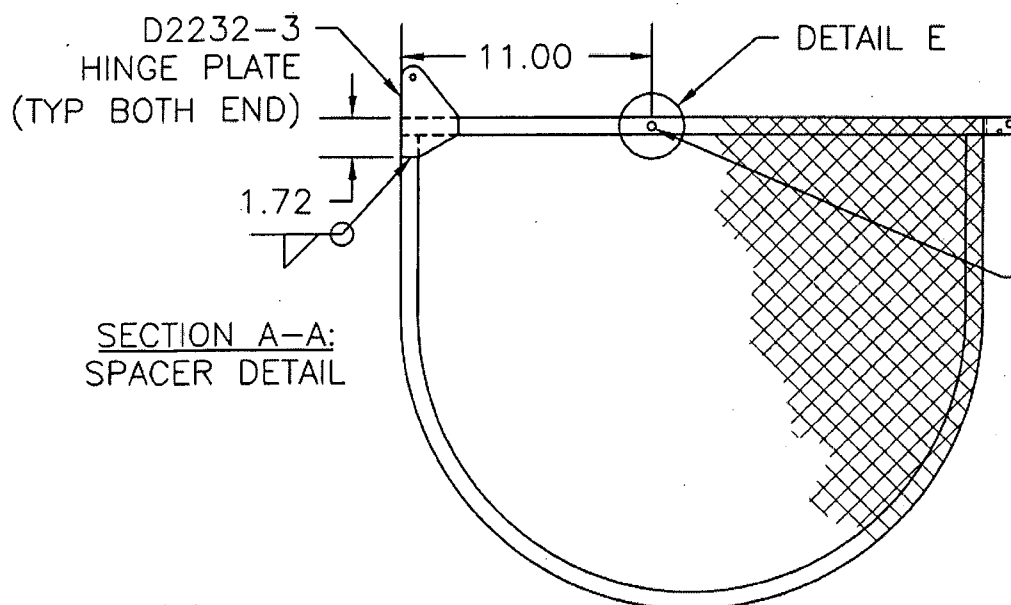


D3053-042 BASKET BASE ASSEMBLY SHOWN
(D3053-041 BASKET BASE ASSEMBLY OPPOSITE)

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NO. 36820B

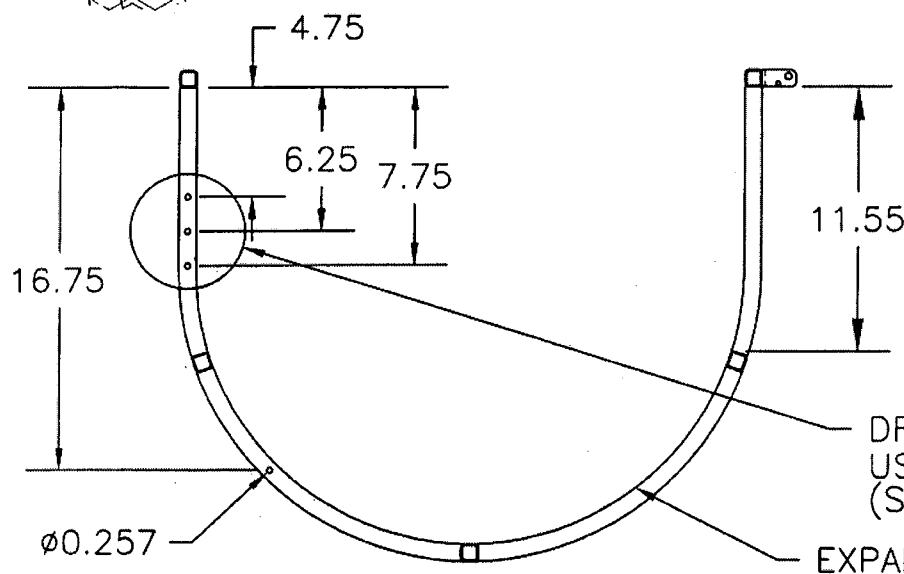
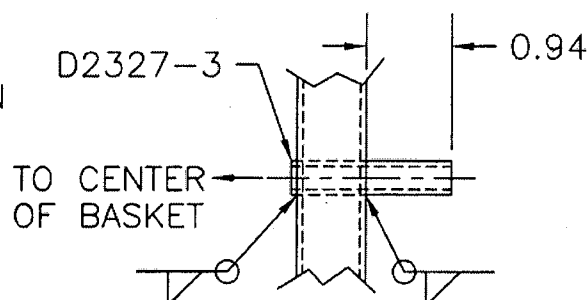
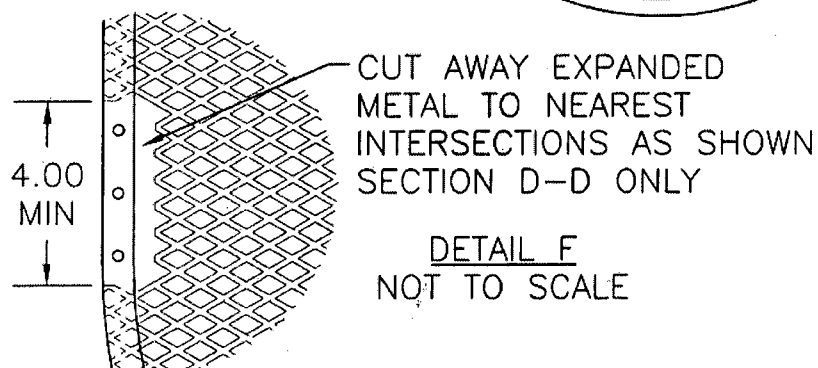


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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3053	REV. A SHEET 3 OF 3
DATE 01.11.01	TITLE BASKET BASE ASSEMBLY (212)		SCALE 1:8



RELEASED
01.12.20

DRILL 3/8 HOLE
AND INSTALL
D2327-3 USING
CLOSEST SPACE IN
EXPANDED METAL
FOR HOLE LOCATION
BOTH ENDS



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WORK ORDER
36820B
SECTION B-B
SECTION C-C AND
SECTION D-D:
RIB DETAIL

DRILL 0.257 DIA HOLES
USE DRILL JIG T2489DJ
(SEE DETAIL F)

EXPANDED METAL

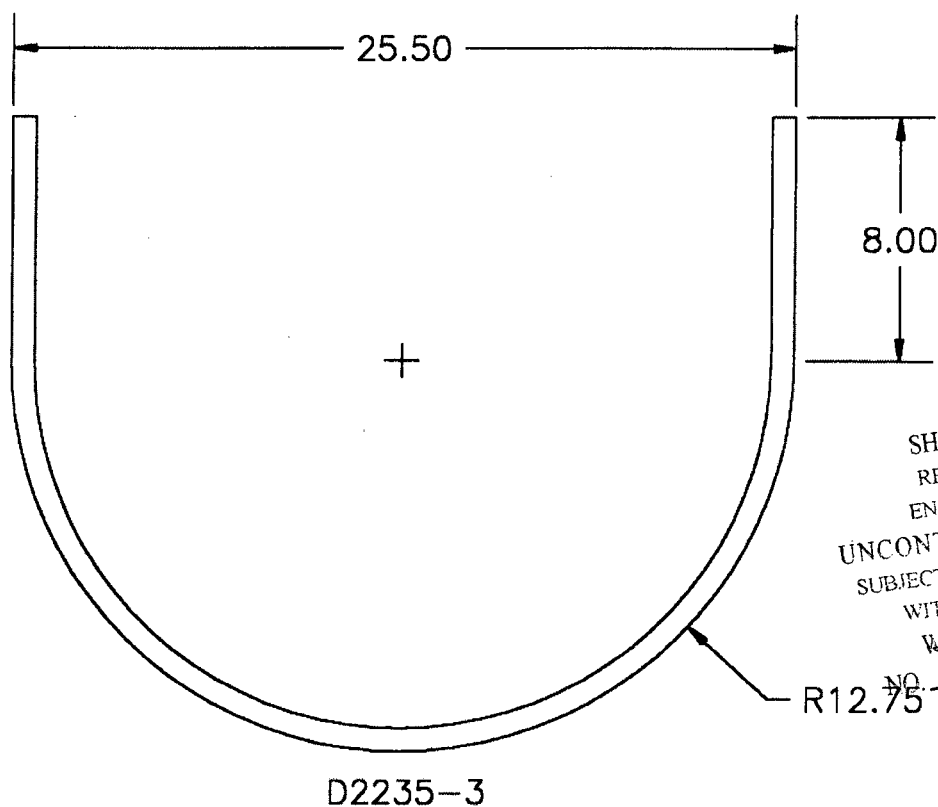
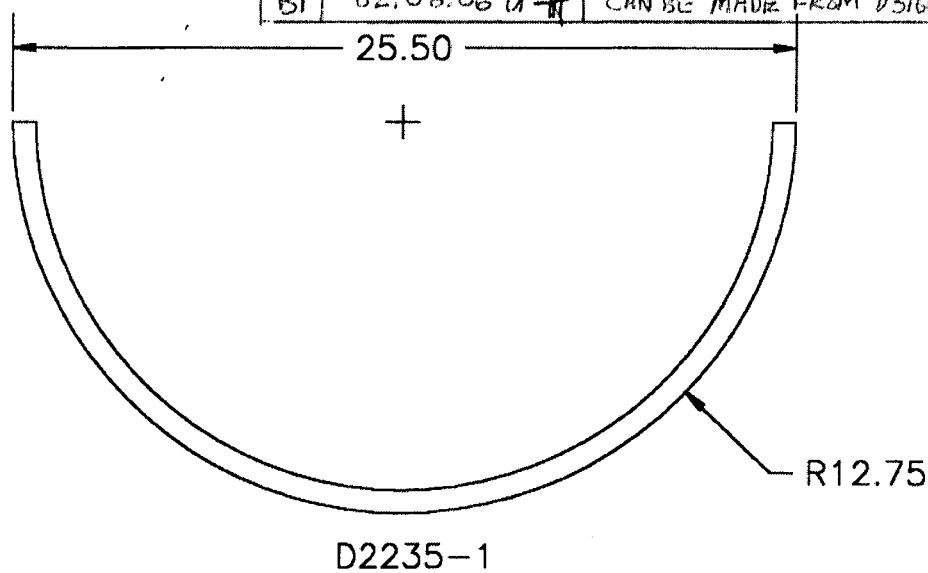
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DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2235	REV. B SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS	SCALE
BI	02.08.06 <i>[Signature]</i>	CAN BE MADE FROM D3166-1	

RELEASED
R 960507



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NO 36820 B

CAN BE MADE FROM D3166-1 *[BI]*
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.